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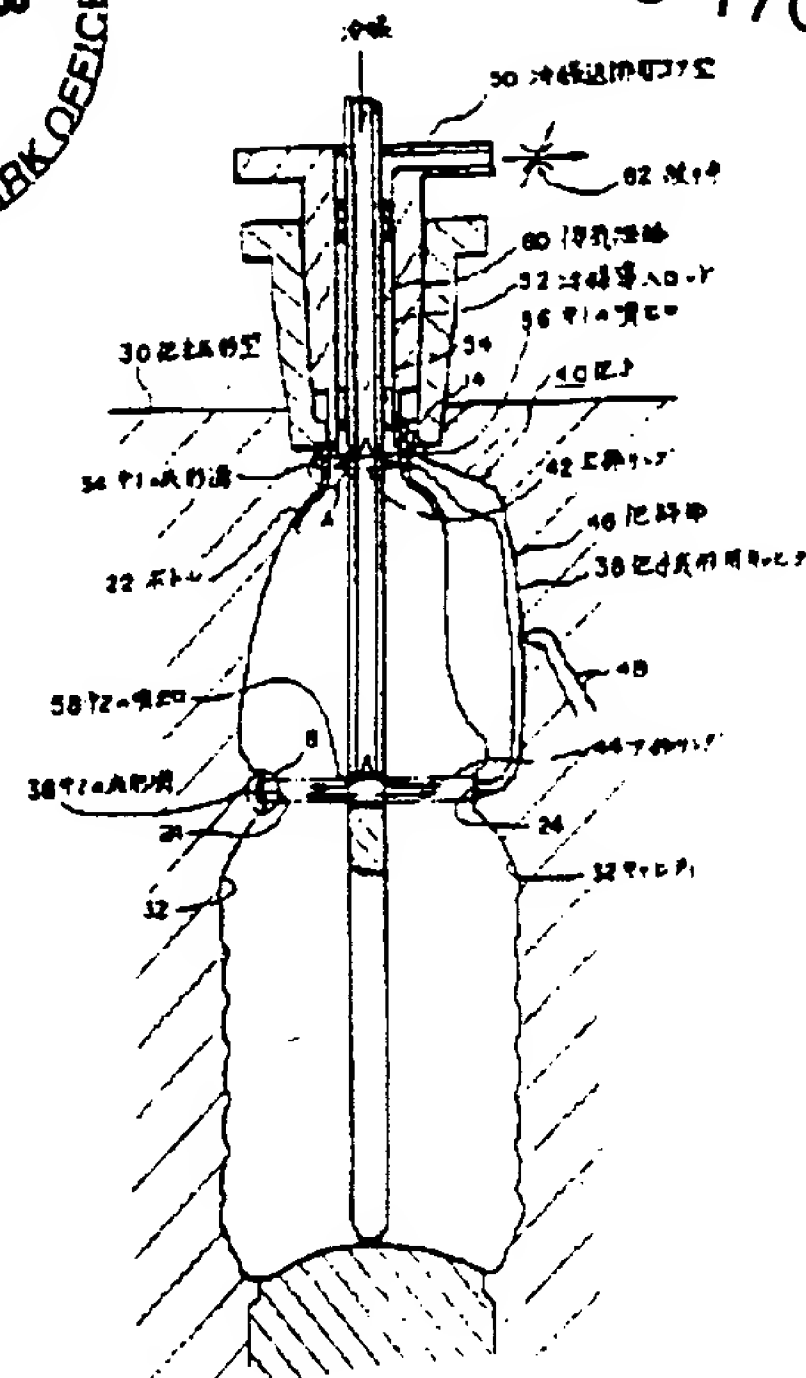
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TITLE : MOLDING METHOD FOR HOLLOW
CONTAINER WITH HANDLE



ABSTRACT : PURPOSE: To eliminate heat deformation of a hollow container and shortage of cooling of a handle resin contact section by jetting a refrigerant locally through a refrigerant introducing rod on the inner face of a container corresponding to a zone where handle molding resin is brought into contact with the hollow container.

CONSTITUTION: PET resin is introduced into a resin path regulated by first and second forming channels 34 and 36 and a peripheral side face opposite to a bottle 22 through a handle forming cavity 38 to injection mold an upper section ring 42, a lower section ring 44 and a handle section 46. Spraying is continued locally from first and second jetting outlets 56 and 58 of a refrigerant introducing rod 52 all over the injection molding process of a handle 40 to cool sufficiently a zone in which PET resin as a molding resin material of the handle 40 is brought into contact with the peripheral side face of the bottle 22. As a result, heat deformation of the bottle 22 molded with PET as the material of same kind as the handle molding resin material can be prevented securely. Also the handle molding resin material can be prevented securely from leaking from the given resin path.

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